

Date: Tuesday, 10/06/2008 12:54:27 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HINGE BRACKET	
Job Number :	39788	Part Number :	D28582	
Estimate Number :	10349	Drawing Number :	D2858 REV B	
P.O. Number :		Project Number :	N/A	
This Issue :	10/06/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	B	
First Issue :	1/1	Type :	MACHINED PARTS	
Previous Run :	36856	Material :		
Written By :		Due Date :	24/06/2008	Qty: 24 Um: Each
Checked & Approved By :	<u>JUD 08.6.10</u>			
Comment :	Est C 00.06.22 Removed P/O for powder coat EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250
 Batch 107461

N.A 08/07/02

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

N.A 08/07/02

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2858-2

SA 08/07/03 24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/07/03 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		23					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 39788

Part Number: D28582

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

24 08/07/03

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

2 N/A

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3 N/A

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

24 BL 08-07-07

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M107925

START TIME:

1:15 pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:45 pm

24 08-07-08

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

24 BL 08/07/08

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST51

24 AS 08/07/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 39788

Part Number: D28582

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39788
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	Ø.171	/			
Ø0.400	+0.005/-0.000	Ø.400	/			
R0.125	+/-0.010	R.125	/			
0.328	+/-0.010	0.328	/			
0.820	+/-0.005	0.820	/			
1.476	+/-0.010	1.480	/			
0.342	+/-0.010	0.343	/			
0.875	+/-0.010	0.875	/			
1.56	+/-0.030	1.566	/			
0.147	+/-0.010	0.152	/			
0.717	+/-0.010	0.717	/			
0.697	+/-0.010	0.693	/			
0.229	+/-0.010	0.233	/			
R0.125	+/-0.010	R.125	/			
R0.063	+/-0.010	R.063	/			
0.063	+/-0.010	0.063	/			
0.126	+/-0.010	0.126	/			
0.630	+/-0.010	0.630	/			
R0.354	+/-0.010	R.350	/			
0.965	+/-0.010	0.968	/			
Ø0.166	+0.005/-0.000	Ø.166	/			

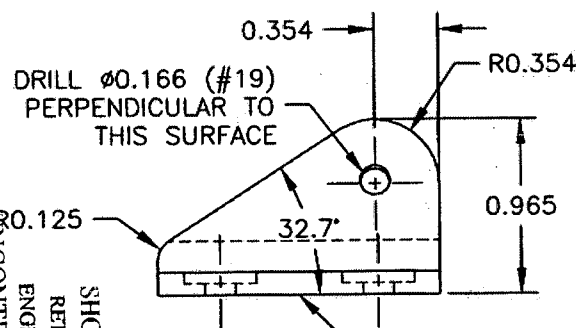
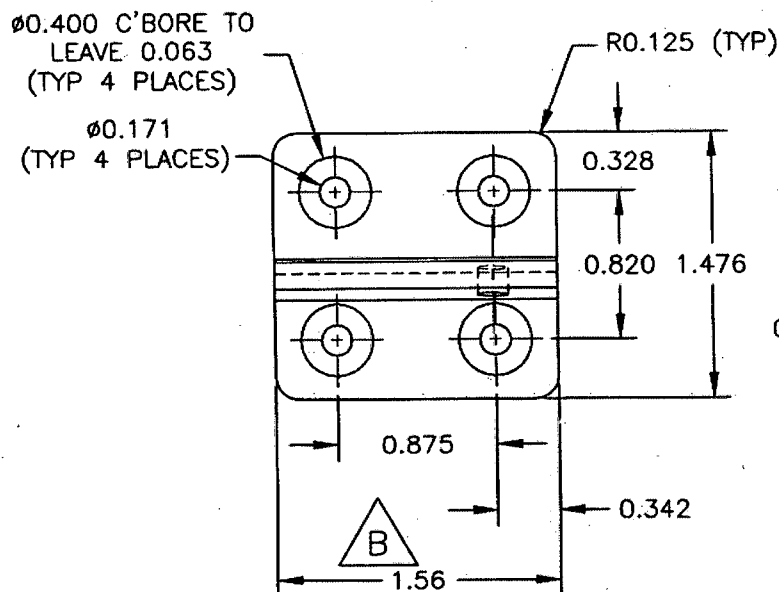
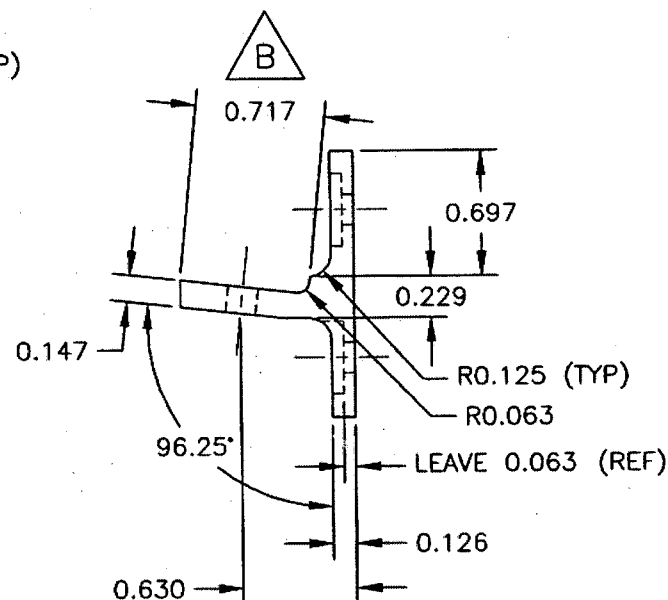
Measured by: SA	Audited by: LJS	Prototype Approval:	N/A
Date: 08/07/03	Date: 08/07/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	SA



RELEASED
99.07.03 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA	REV. B
CHECKED CP	APPROVED KE	DRAWING NO. D2858	SHEET 1 OF 1
DATE 99.02.28	TITLE HINGE BRACKET	SCALE 1:1	
A	98.12.14	NEW ISSUE	
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559	



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 301788